

Work Order ID 115202

March-17-14 2:57:17 PM

Super Rush

\*115202\*

Page 1

Item ID: D2438

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Clamp

Start Date: 3/17/14 Start Qty: 100.00

\*100\*

Cust Item ID:

Required Date: 3/20/14 Req'd Qty: 100.00

\*100\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2438

Rev C

D2727

A1

100

\*100\*

Waterjet

FLOW CNC Waterjet

PURCHASING

Memo

Cut as per dwg D2438

prog rev: C

dwg rev: C

0.00

0.00

102  
~~104~~ EL 14-3-18

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Ensure Material Release Note is attached

0.00

0.00

102  
~~104~~ EL



**Work Order ID 115202**

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**\*115202\***

Page 2

Item ID: D2438

Accept

**\*N1900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Clamp

Start Date: 3/17/14

Start Qty: 100.00

**\*100\***

Cust Item ID:

Required Date: 3/20/14

Req'd Qty: 100.00

**\*100\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

Quality Control

(6.786" center to center)

0.00

27  
9-89  
14/3/18

102

130

Small Fab

0.00

**\*130\***

Small Fab

Memo

Small Fab

1- Use DT9713 clamp holder to hold clamp in place when forming  
2- Bend as per dwg usind DT9709

0.00

DAS  
30  
9-89

102

14/3/19

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

Quality Control

0.00

DAS  
27  
9-89  
14/3/19102  
cont



# Work Order ID 115202

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Page 3

Item ID: D2438

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Clamp

Start Date: 3/17/14

Start Qty: 100.00

\*100\*

Cust Item ID:

Required Date: 3/20/14

Req'd Qty: 100.00

\*100\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location:

0.00

\*150\*

Packaging

Memo

(12x) PPP 106875  
(6x) PPP 103023  
(84x) ST 456

0.00

Packaging

102x DAS 28 14-03-19  
9-89

160

QC21- Final Inspection - Work Order Release

0.00

\*160\*

QC

Memo

Quality Control

0.00

MLJ 14-03-20

MLJ 14-03-20



# Picklist Print

March-17-14 2:57:16 PM

Page 1

Work Order ID: 115202

\*115202\*

Parent Item: D2438

\*D2438\*

Parent Item Name: Clamp

Start Date: 3/17/14

Required Date: 3/20/14

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: E05.06.28Bending removedKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	274.8270	0.04	5			

\*M304S16GA\*

304/316 Sheet .063

\*\*

mm 14/03/18

Location

Loc Qty

Loc Code

MAT020

274.827

M126915

1.487

M127821

126.13

M128054

34.04

M128421

113.17

5.5





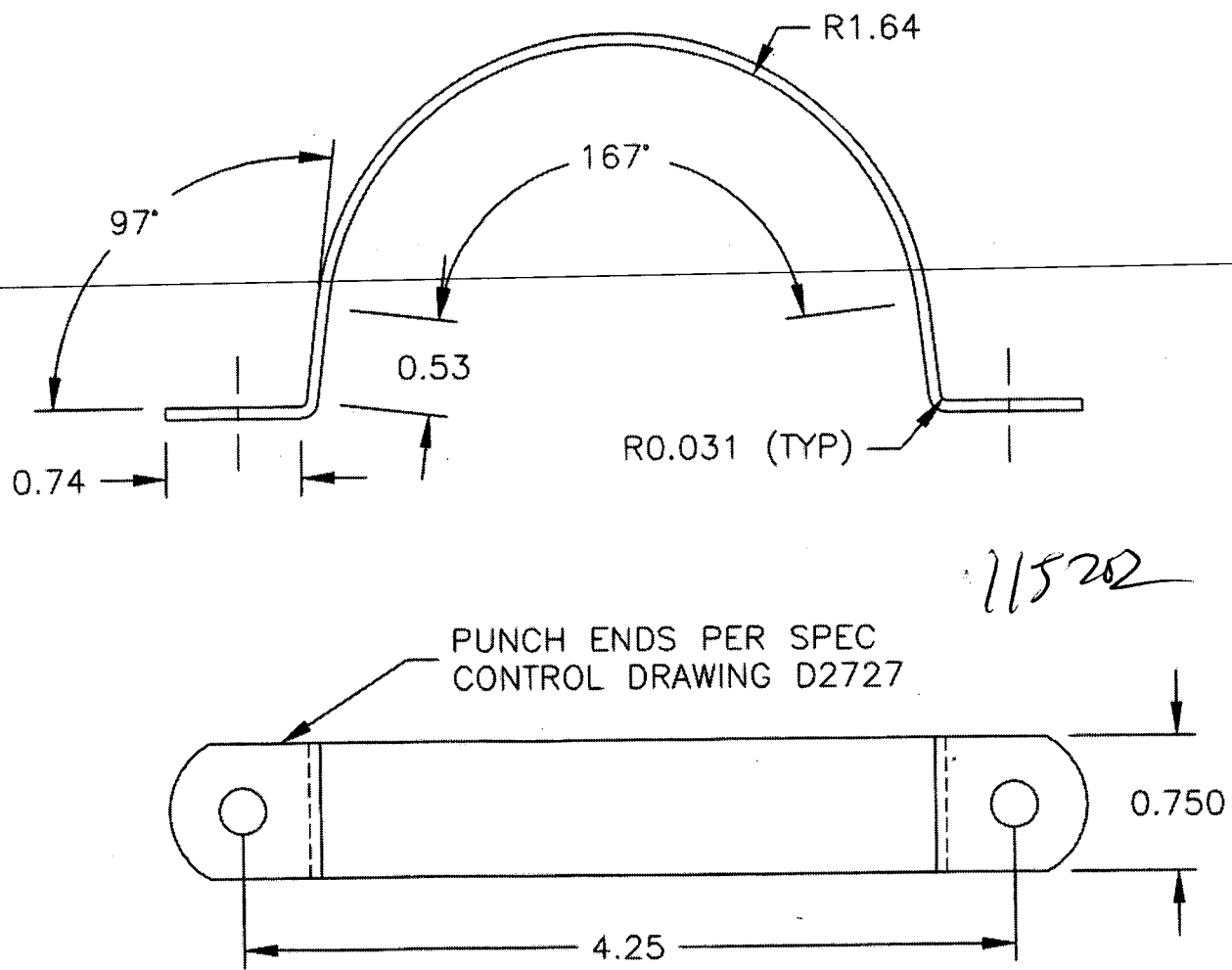






DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MS</i>	APPROVED <i>MS</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED  
98.06.17 KE



FLAT LENGTH: 7.586 END-END  
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK  
MINIMUM REQUIREMENT IS ANNEALED CONDITION

# 00.06.06  
CP 00.06.07